

Thursday, November 25, 2010 2:52:15 PM

Page 1

Accept

**Setup Start**

Stop

**Cust Item ID:**[illegible]

Customer:

Reference:

Date: 12-11-25 Tooling:

Date:

Run Start

QC:

Date: _____ **SPC (Y/N):** _____

Date:

Stop

**Insp.
Stamp**

Revision Nbr

Rev E

Weld per dwg A/R S.S. rod Batch: M114649 0.00

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

4-Weld as per Dwg D2512 using Welding Jig DT 9436

Deburr as required

INSTALL D2012-117 CLEVIS ONLY ON D130-701-041

QC9- Inspect visual per QSI004- Fusion Welds

0.00

[illegible]

QC

Memo

0.00

Quality Control

Pl 10.12.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64142

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Page 2

Item ID: D2512

Accept



Setup Start



Revision ID:

Item Name: Basket Lid 205/350

Stop



Start Date: 11/25/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 12/3/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

8012/17

=> 10/12/17

10

1

Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64142



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Thursday, November 25, 2010 2:52:15 PM

Item ID: D2512	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Basket Lid 205/350				
Start Date: 11/25/2010	Start Qty: 1.00		Cust Item ID:	
Required Date: 12/3/2010	Req'd Qty: 1.00		Customer:	
Reference:				

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 115951</i> Memo 1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat 1ST COAT: START TIME: <i>10:10</i> OVEN TEMPERATURE: <i>400°</i> FINISH TIME: <i>10:40</i> 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.00				<i>1</i>		<i>10-12-17</i>	

140 HandFinish Hand Finishing	HandFinishing Memo Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4 Batch: <i>M11579</i> spray BLK: <i>M116123</i>	0.00 0.00	<i>2 M</i>	<i>10/14/20</i>		<i>1</i>	<i>Q</i>		
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64142

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Thursday, November 25, 2010 2:52:15 PM

Item ID: D2512

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid 205/350

Start Date: 11/25/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 12/3/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 QC3- Inspect Part Finish 0.00



QC Memo 0.00

Quality Control

ES 10/12/20 @

160 Identify as per dwg & Stock Location *G.A* 0.00

Packaging Memo 0.00

Packaging

ES 10/12/20 @

170 QC21- Final Inspection - Work Order Release 0.00



QC Memo 0.00

Quality Control

10/12/20
MF
10-12-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 64142

Parent Item: D2512

Parent Item Name: Basket Lid 205/350



Start Date: 11/25/2010

Required Date: 12/3/2010

Start Qty: 1.00

Required Qty: 1.00

Comments:
 Rev IPP:M03.01.31 AddedD2012-117forD130-701-041□KJ/RF
 IPP Rev:N□06.04.05 Added level21 EC
 IPP REV:O ADDED D3490-1/-3 FOR D130-701-011/-043 10-04-20 JLM
 VERIFIED BY:DD
 IPP Rev:P 08-08-29 revE as per dwg DD verified by:EC
 IPP Rev:Q 08-09-24 plug holes prior to powder coating DD verified
 by:EC IPP Rev:R 10.06.29
 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2012-117		Manufactured	No			100	Each	28.0000	2	2			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Clevis

Location	Loc Qty	Loc Code
WA	28	
3091	1	
55729	27	

*** ONLY APPLICABLE ON D130-701-041 -IF
 NOT USED, PLEASE MARK N/A ***

✓ D2232-1		Manufactured	No			100	Each	18.0000	2	2			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Basket Hinge

Location	Loc Qty	Loc Code
WA	18	
55791	18	

✓ D2327-1		Manufactured	No			100	Each	17.0000	2	2			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Spacer Bushing

Location	Loc Qty	Loc Code
WA	17	
54658	5	
60174	12	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 64142

Parent Item: D2512



Parent Item Name: Basket Lid 205/350

Start Date: 11/25/2010

Required Date: 12/3/2010



Start Qty: 1.00

Required Qty: 1.00

✓ D2506 Manufactured No 100 Each 6.0000 1 1

 Label Plate  10/12/10



Location Loc Qty Loc Code

WA 6 6
 63254 6

✓ D2581 Manufactured No 100 Each 27.0000 2 2

 Mounting Bracket  1x
10/12/10

Location Loc Qty Loc Code

WA 27
 61953 20
 63493 7

✓ D3166-3 Manufactured No 100 Each 6.4231 1 1

 Basket Hoop  2x
SAD 10-12-10

Location Loc Qty Loc Code

WA 6.423071053
 55697 2.1053E-05
 59266 0.0418
 60270 0.00265
 61193 0.3786
 63063 6

B64249 5
1

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 64142

Parent Item: D2512

Parent Item Name: Basket Lid 205/350

Start Date: 11/25/2010

Required Date: 12/3/2010

Start Qty: 1.00

Required Qty: 1.00

✓ M304EX0.75-16F Purchased No

100 sf

1,124.643

18

18.94737



Expanded Metal Flat SS



SAD

10-11-14

Location

Loc Qty

Loc Code

MAT

1124.643833

114809

85.422943

114853

11.80059

115012

393.8315

115067

13.0125

115171

6.0394

115401

72.0095

115665

5.6216

115989

216.9058

116178

320

18.94

✓ M304TS0.750W.065 Purchased No

100 f

189.1682

43.5804

45.87411



304 SQ Tube .75x.75x.065W



SAD

10-12-10

Location

Loc Qty

Loc Code

MAT

89.43205

112398

0

115494

4.4725

115593

84.95955

WA

99.736185

115274

4.712185

115901

95.024

7116267

45.8742

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Shop Packet Print

Page 3

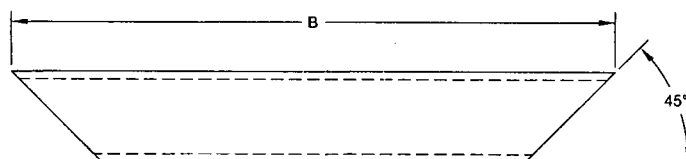
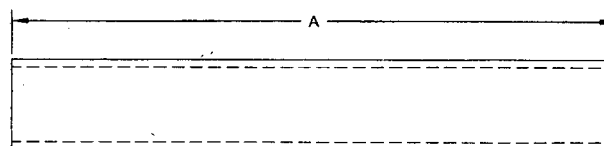
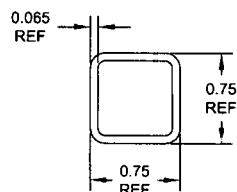
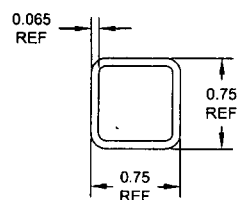
PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 04142

38101125

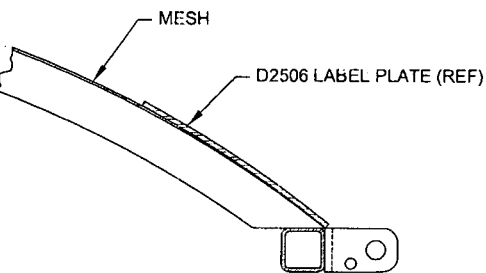
RELEASED
08.08.21/11



D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

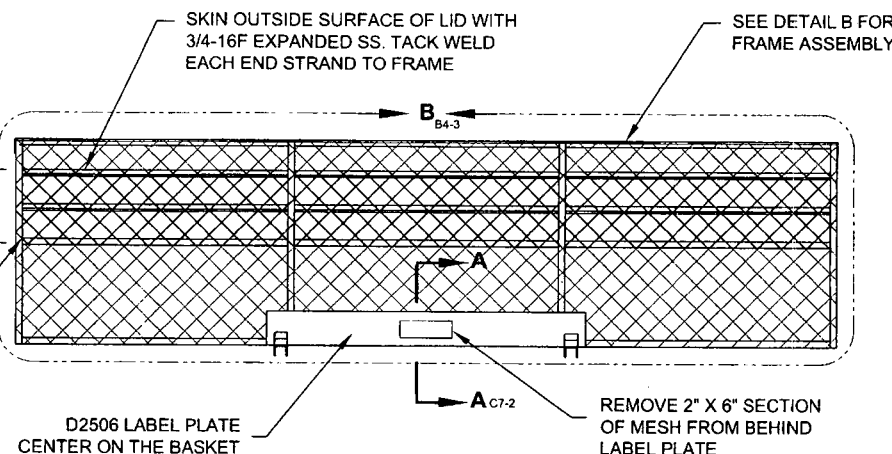
E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO 'B' FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D2512	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR IN ANY MANNER OR FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



SECTION A-A_{B3-2}
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED



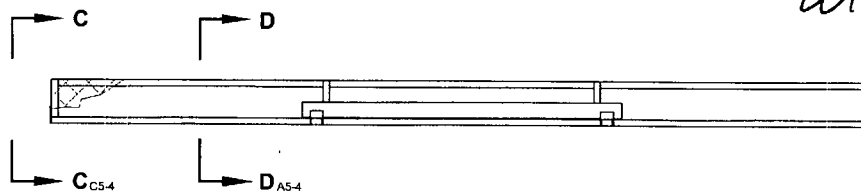
D2506 LABEL PLATE
CENTER ON THE BASKET

REMOVE 2' X 6' SECTION
OF MESH FROM BEHIND
LABEL PLATE



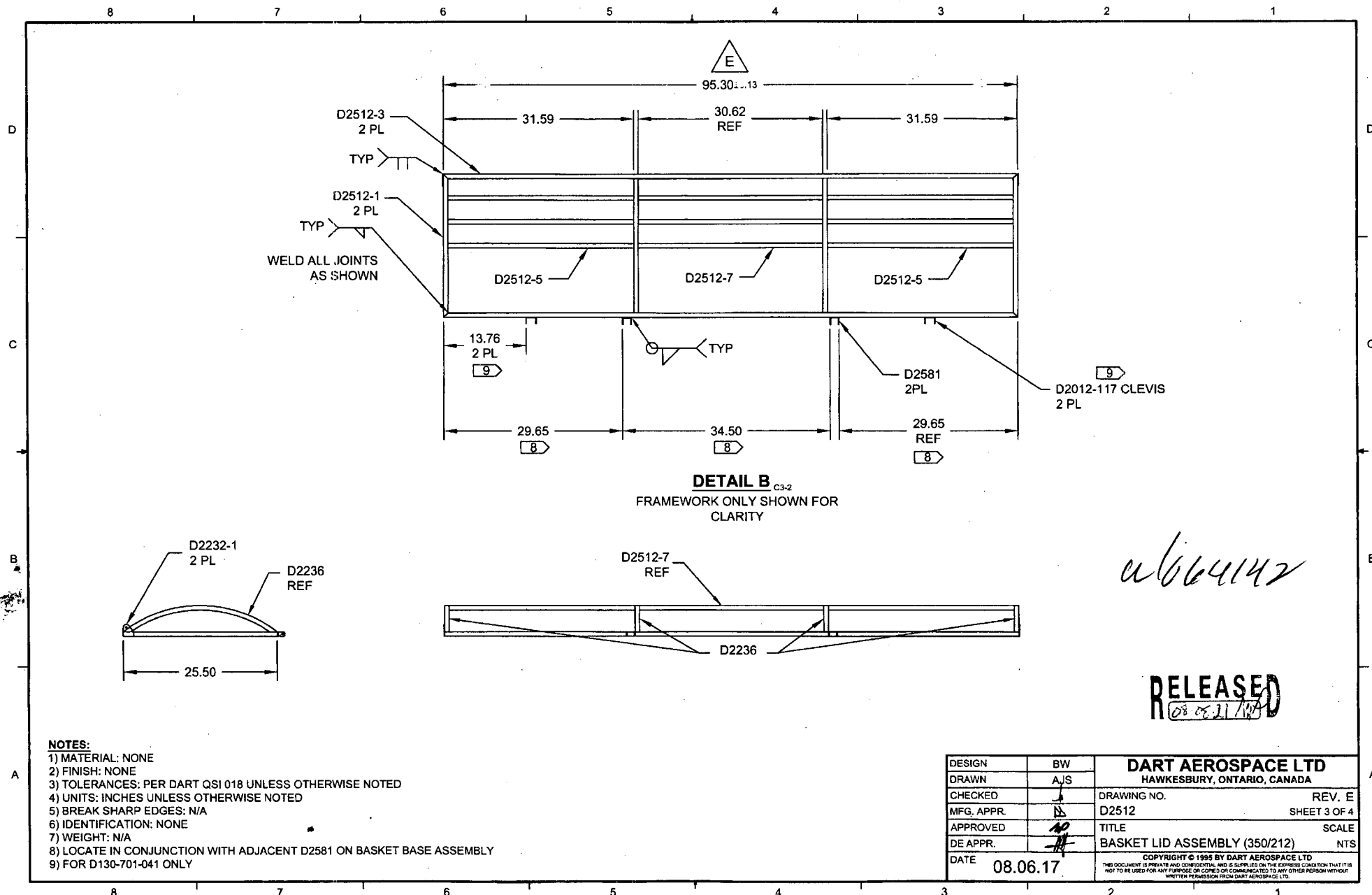
D2512 BASKET LID ASSEMBLY NOTES:

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

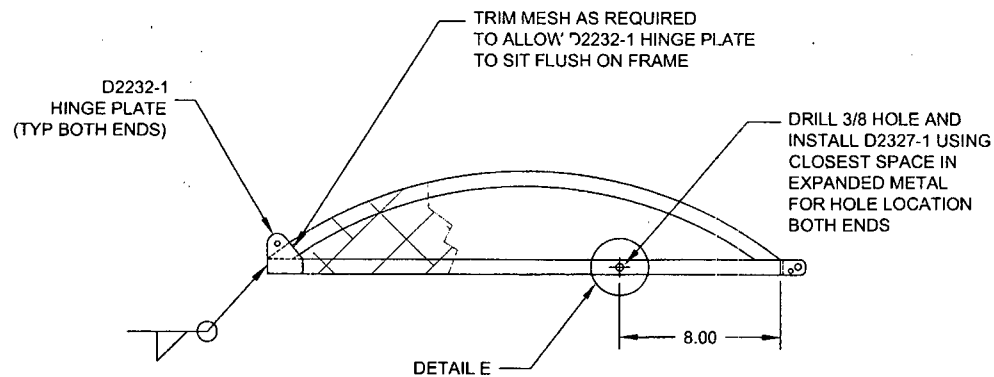


RELEASED
08.06.17

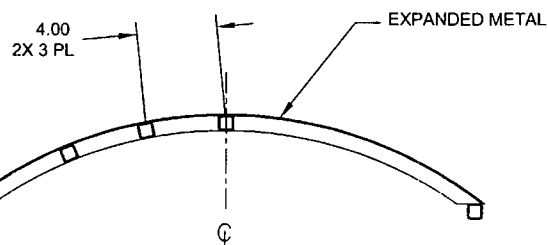
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



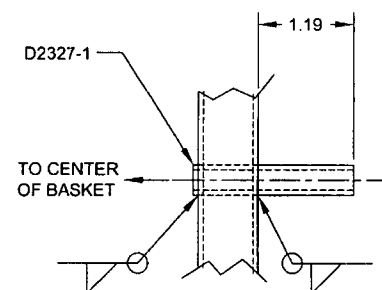
8 7 6 5 4 3 2 1



VIEW C-C SIMILAR BOTH END RIBS A5-2



SECTION D-D SAME BOTH CENTER RIBS A4-2



DETAIL E C6-4

WLO 44142

RELEASED
08.06.17

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1